

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020985**Date Inspected:** 19-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

BAY14

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 08347. The member(s) is/are identified as Edge Plate Stiffeners to Floor Beam. The weld designations reviewed are as follows:

SEG3007AB-077, 079, 081, 083, 085, 054, 056, 058, 060, 062,

SEG3007AB-053, 055, 057, 059, 061, 042, 044, 046, 048, 050,

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 08345. The member(s) is/are identified as Longitudinal Diaphragm to Bottom Plate. The weld designations reviewed are as follows:

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SEG-3020Z-077, 078, 079, 080

This QA Inspector observed the following work in progress:

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019BB Brace Plate to Vertical Plate weld number(s) 114 and 115. Welder is identified as welder no. 0676710. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019AA Longitudinal Diaphragm to Bottom Panel weld number(s) 025. Welder is identified as welder no. 067656. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR-2755

SMAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007H Floor Beam to Bottom Plate weld number(s) 101 and 099. Welder is identified as welder no. 037705. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-B-P-2213-TC-U4b-FCM-1.

SMAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007AD Side Plate to Floor Beam weld number(s) 041. Welder is identified as welder no. 037743. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-345-SMAW-1G (1F)-FCM-Repair-1 and B-WR-20210

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
